

Accept

Work Or	der ID	57969
April 21, 2010	9:23:16	AM

Item ID:

D4038-5

Revision ID:

Item Name:

Block

Start Date:

23/04/2010

Start Qty: 4.00

Req'd Qty: 4.00 Required Date: 30/04/2010

Reference:

Approvals:

Process Plan:

QC:

Sequence ID/ **Work Center ID**

Operation **Description**

Draw Nbr

Revision Nbr

D4038

В

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.19" LONG

Date:

Date:

105

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA883 DWG REV:

FOLIO REV:

DEBURR



Setup Start

Stop

Cust Item ID: **Customer:**

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Set Up/ Run Hours Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number Stamp

Insp.

0.00

0.00

0.00

0.00 ml 10/04/25

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23/04/2010

Start Qty: 4.00

Required Date: 30/04/2010

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Accept



Run

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/ Work Center ID

110

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours** 0.00

Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number Stamp

Insp.

Quality Control

out 10/04/25

120

Quality Control

QC8- Inspect parts - second check

Memo

0.00

B.A 10/04/26

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

0.00

) Bl 10- 1 Xo.

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QC:

Date:

Date:

Accept

SPC (Y/N):

Tooling:

Date:

Cust Item ID:

Customer:

Date:

Draw

Rev.

Plan

Code

Run

Reject

Qty

Setup Start

Stop

Reject

Start

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

150

Quality Control

Operation Description QC3-Inspect Part Finish

Memo

Set Up/ **Run Hours** 0.00

Draw

Number

10/04/26

Accept

Qty

\$

160

Packaging

Packaging

Memo

Identify as per dwg & Stock Location: ST 110_{0.00} M.L w/04/26

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

0.00

10/04/27 A

Picklist Print

124

April 21, 2010 9:23:16 AM

Work Order ID: 57969

Comments:

Item Name

D4038-5 Parent Item:

Parent Item Name: Block

lpp Rev:A New Issue 09-12-14 JLM Verified By:EC

Replacement Mfg/ Item ID

Purch

Bin Primary Location Item

Last Location Route Seq ID

Unit of Qty on Measure Hand

0.6989

Start Date: 23/04/2010

Qty

Issued

Start Qty: 4.00

Remaining

Qty To Pick

Date Issued

Required Date: 30/04/2010

Required Qty: 4.00

Status

Page 1

M6061T6B1.500X02.00

Component Item ID/

Purchased

No

9.5000

6061-T6 Bar 1:50 x 2.00

Warehouse

Loc Qty

Location

Main Warehouse

MAT10

110167

Loc Code

.6989 onf 10/04/24

9.5 9.5

DART AEROSPACE LTD	Work Order: 57969
Description: BLOCK	Part Number: DY038-5
Inspection Dwg: 04038Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
1.30	±,030	1.296	/ "				
R.13	±,030	R.125					
2.06	± 03b	2.062	_				
1.563	7.000	1.561					
1.063	+.005	1.061					
Ø.316	+.006	Ø. 319					
,581	I.016	. 581					
.669	±-005	448					
1.75	±.030	1.757					
1.75	· ±.03b	1.750					
, 50	±.030	.500					
. 50	-	500		,			
0.189	±.030 +.005 001	8.192					
Ø,50 X,501	DEEP + . 030 X + . 030	Ø. 500X 50	0				
			,				
		<u> </u>					
Measured by:	ant,	Audited by:	B.A		Prototype App	oroval:	N/A
Date:	10/04/25	Date:	10/04	126	`	Date:	N/A

Measured by:	ant.	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/04/25	Date:	10/04/26) Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

8 3 2 w/o 57969 ß 0.50 REF Ø0.189 THRU C'BORE Ø 0.50 X 0.50 DEEP 0.50 0.50 REF B D4038-С C 1.563 1.75 1.063 2.06 0.669 Ø0 316 R0.13 TYP **D4038-5 BLOCK** NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M606116B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA URAWING NO. CHECKED REV. B D4038 MFG. APPR SHEET 7 OF 14 TITLE APPROVED SCALE BRACKET DE APPR THE DOCUMENT OF 2009 BY DART AEROSPACE LTD
THE DOCUMENT OF FRONT, AND CONTROL AND ASSET OF THE STREET CONTROL AND ASSET OF THE STREET CONTROL AND ASSET OF COMMISSIONS TO AND ASSET OF AN AND ASSET OF THE STREET CONTROL AND ASSET OF THE ASSE DATE 10.01.05

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